

Work Order ID 86977

86977

Page 1

July-10-12 9:12:05 AM

Item ID: D3026-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Channel

Start Date: 7/10/12 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 8/10/12 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/07/11 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3026	C					5			

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3026

Dwg Rev: E

Prog Rev: E

2-Deburr if necessary

12-7-24

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

12-7-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86977

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Page 2

Item ID: D3026-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Channel
Start Date: 7/10/12 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 8/10/12 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 SMB 127-24 0.00	DAS 1E 2-8 12/4/25			5			
130 *130* Brake NC Brake NC	Form as per dwg NC BRAKE Memo	0.00 0.00				5			8 12/4/25
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	DAS 16 2-8 12/4/25			(B)			

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Page 4

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Item ID: D3026-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Channel

Start Date: 7/10/12 Start Qty: 2.00

2

Cust Item ID:

Required Date: 8/10/12 Req'd Qty: 2.00

2

Customer:

Reference:


Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/17/31 

MLJ 12/07/30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

July-10-12 9:12:04 AM

Page 1

Work Order ID: 86977

Parent Item: D3026-1

Parent Item Name: Channel

Start Date: 7/10/12

Required Date: 8/10/12

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP D05.10.07Added forming step and Issue P/OKJ/JLM
IPP E 07.01.04 waterjet ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050 2024-T3 .050 sheet		Purchased	No			100	sf	253.5000	0.64	1.3473684	3.5	12-7-24	

Location

Loc Qty

Loc Code

MAT022

253.5

117684

22.8

121216

89.2

121889

141.5

121 216

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Dart Aerospace Ltd

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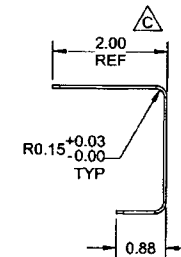
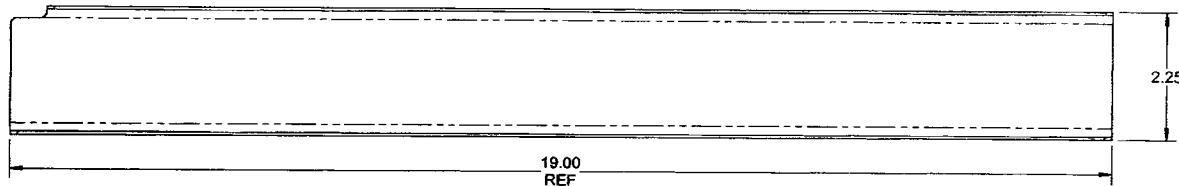
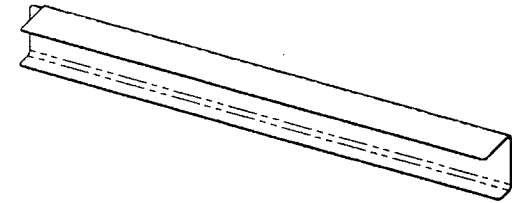
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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 86977 MCL
12/07/11



D3026-1 CHANNEL

RELEASED
2011-05-26
W

NOTES:

- 1) MATERIAL: MAKE FROM D3026-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 0.46 lbs

C	FORMAT TO CURRENT STD; 2.00 REF WAS 0.88 (C2-1); UPDATED FLAT PATTERN; 4.87 WAS 3.740 (C8-2). REF. PAR11-104/NCR11-574.	MB	11.05.13
B	REMOVE HOLES	CP	05.09.20
A	NEW ISSUE	RF	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3026 TITLE CHANNEL SHEET 1 OF 2 SCALE NTS REV. C DATE 11.05.13 <small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED IN THE CORRECT LOCATION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		

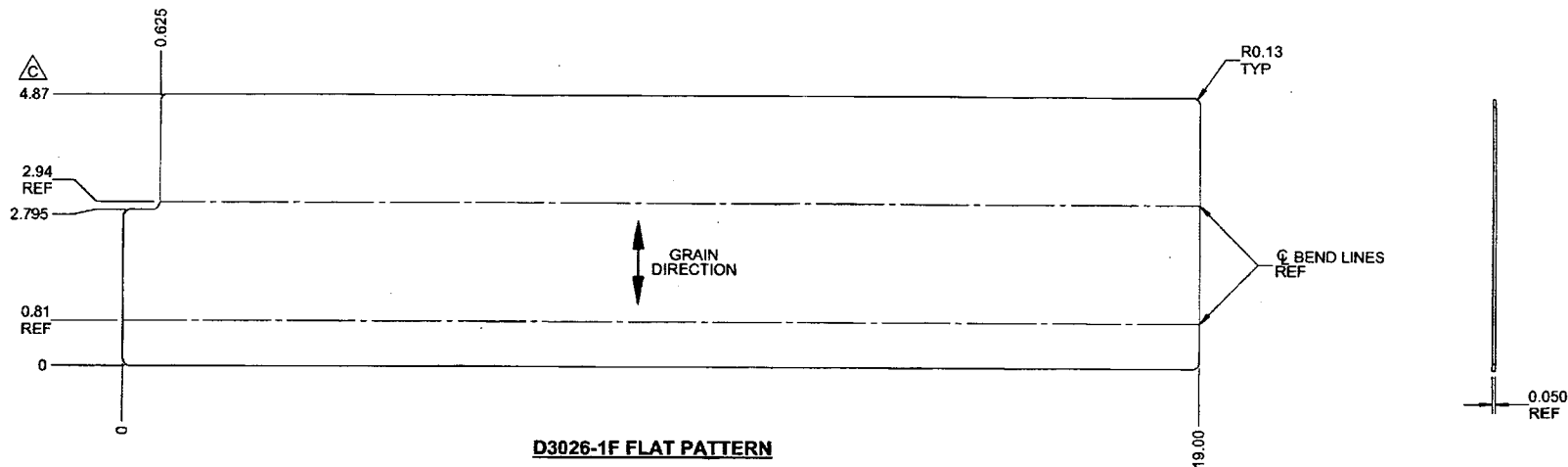
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D3026-1F FLAT PATTERN

RELEASE
2011-05-24
MD

NOTES:

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK
FER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
REF DART SPEC M2024T3S.050
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.46 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3026 TITLE CHANNEL	REV. C
DRAWN			SHEET 2 OF 2
CHECKED			SCALE
MFG. APPR.			NTS
APPROVED			
DE APPR.			
DATE	11.05.13	COPYRIGHT © 2001 BY DART AEROSPACE LTD. THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED TO THE CLIENT UNDER THE PROVISIONS OF THE ACCESS TO INFORMATION ACT. IT IS NOT TO BE USED FOR ANY PURPOSE OR PURPOSES UNRELATED TO THE ORIGINAL PURPOSE FOR WHICH IT WAS PROVIDED.	

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